

Date: Wednesday, 7/11/2007 2:46:15 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LID PRO ARM ASSEMBLY (SHORT)		
Job Number :	33467				
Estimate Number :	10258				
P.O. Number :	N/A	Part Number :	D2332041		
This Issue :	7/11/2007	S.O. No. :	N/A		
Prsht Rev. :	NC	Drawing Number :	D2332 REV C1		
First Issue :	MM	Project Number :	N/A		
Previous Run :	32572	Drawing Revision :	C1		
		Material :	N/A		
Written By :			Due Date :	7/30/2007	Qty: 20 Um: Each
Checked & Approved By :	<u>7/11/07</u>				
Comment :	Est: B 02.06.12 Re-format; Incorporated D2332-13/11-7/5 K J/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4331 f(s)/Unit Total : 8.6625 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

M 103844 ② M 105260 182

Batch

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)

Material: Ø0.250" 304SS Rod

Batch: M 105950 ⑫ M 14686 ⑧

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

Handwritten notes:
~~105260~~ 07/10/22 ②
~~105260~~ 07/09/17 ①7
 07/09/17 ②

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2502 f(s)/Unit Total : 25.0040 f(s)

304 RD Tube .500 x .035W

M 104880 ~~105260~~ M 104862 6X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:46:15 PM
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Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

FF 07-08-16

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch:

~~M105360~~ / ~~M110100~~ / ~~M110595~~ M105524

07/11/03

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

Bolt

10.0

AN44A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M101291

07/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: _____ Fault Category: Prod / P.B. Ass. med & Small NCR: (Yes) No DQA: LD Date: 07/11/15
 QA: N/C Closed: KJ Date: 07.11.15

NCR: <u>33427</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/16	5	6 prop arm (D2332-11) Damaged due to MTRL on punch	<u>QSIOL</u>	Destroy + Replace	<u>JB</u> 07/10/16	<u>Mulos</u>	<u>QSIOL</u>	<u>JP</u> 07/08/16

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 33467

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

1105408

CP 07/11/12

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

1105054

CP 07/11/12

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-14 20

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 203

07/11/15

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/15

Job Completion



07-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

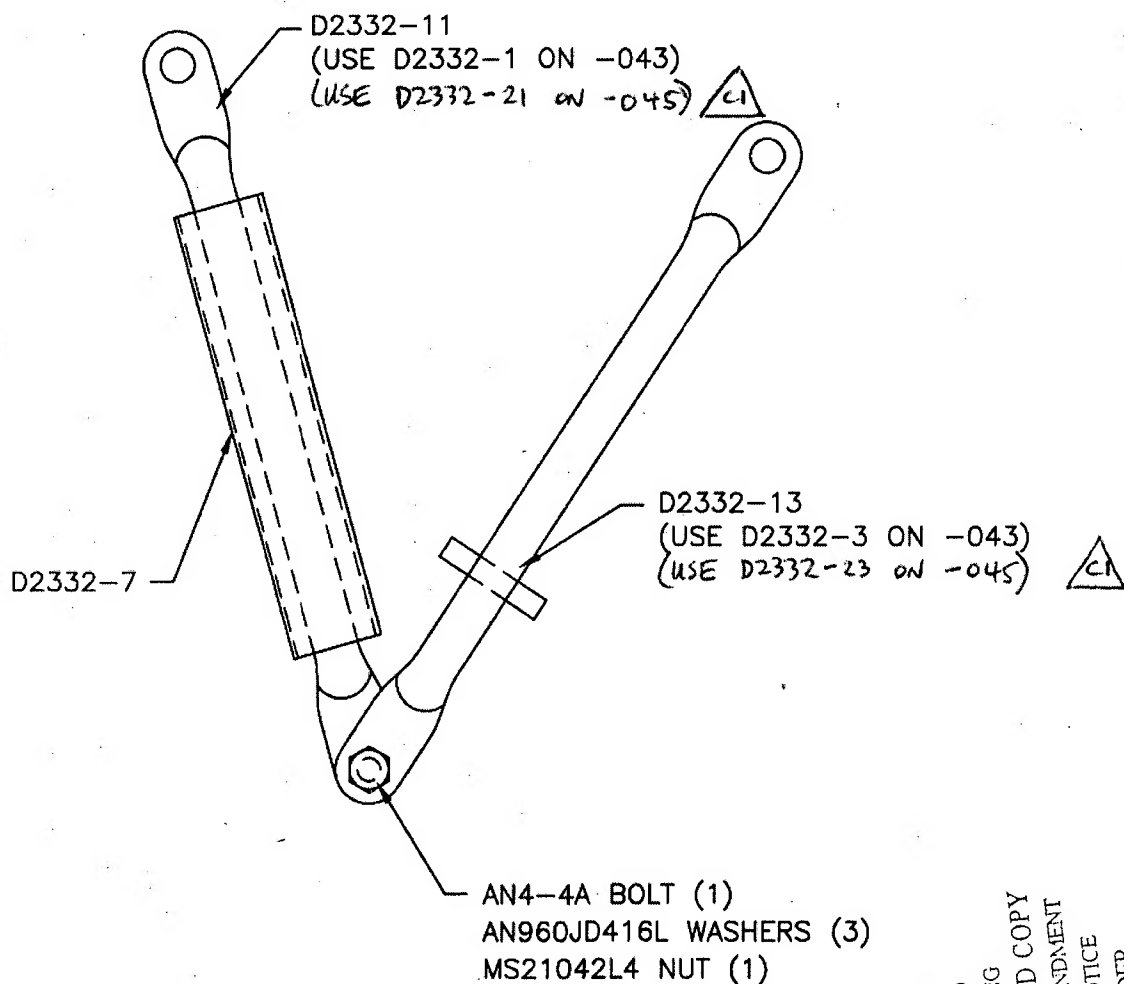
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	#40 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



D2332-041 SHOWN
(D2332-043 SIMILAR)
(D2332-045 SIMILAR)



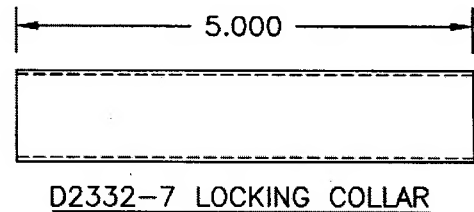
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WITHOUT NOTICE
WORK ORDER
NO. 33467

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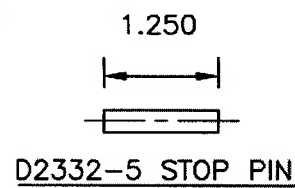
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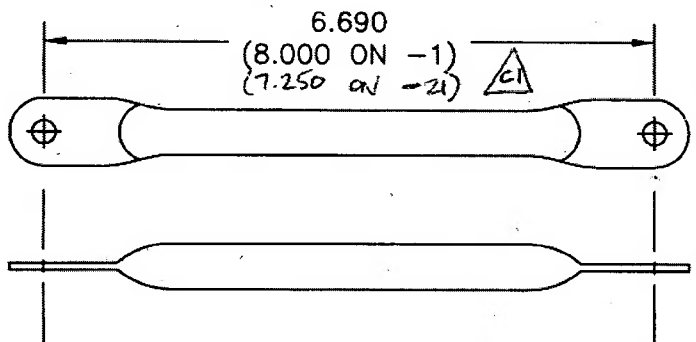
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE: 03.07.03	TITLE: LID PROP ASSEMBLY	REV. C
	DRAWING NO. D2332	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE - 041 PROP 6.64" LONG (END)
C1	03.08.06	MAKE - 043 PROP 8.00" LONG (END)
		ADD - 045 PROP (7.25" LONG)



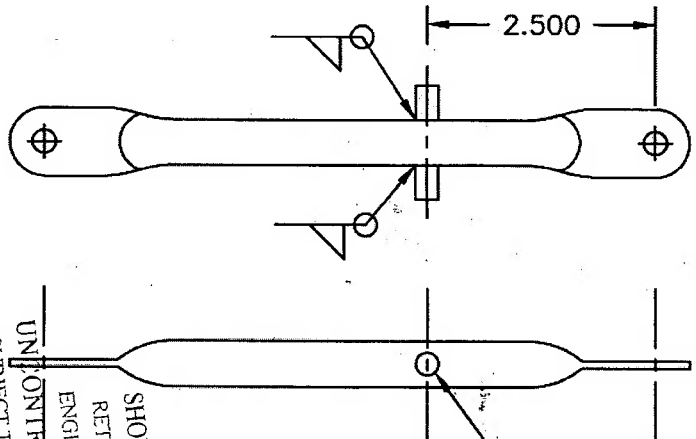
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33467

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

